

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019578**Date Inspected:** 11-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhang Lin. AB Flour QA is Yu Tiau.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG Floor Plate to SEG3007X

PCMK: SEG3007L

Weld No: 045

Welder: 215553

Weld Repair No. B-WR18556

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Component; OBG

PCMK: SEG3007AT

Weld No: 095

Welder: 216086

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Weld Repair No. B-WR19146
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Component; OBG 14W (see photos below)
PCMK: SEG3019AL
Weld No: 295
Welder: 067656
WPS-B-T-2114-FCM-1

Component; OBG 14W
PCMK: SEG3019AL
Weld No: 008
Welder: 069683
WPS-B-P-2114-FCM-1

Component; OBG 14W
PCMK: SEG3019AL
Weld No: 009
Welder: 037723
WPS-B-P-2114-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhu Lin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA Inspector.

Component; OBG
PCMK: SEG3020K
Weld No: 009,
Welder: 066734, 067520
Critical Weld Repair No. B-CWR2691
NDE Report No. B-787-UT-18525
WPS-345-SMAW-2G(2F)-FCM-Repair

Component; OBG
PCMK: SEG3020K
Weld No: 021
Welder: 201215
Weld Repair No. B-WR19831
NDT Report No. B787-UT-18525
WPS-345-SMAW-3G(3F)-FCM-Repair

This QA Inspector observed the following work in progress for Bay 14.

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ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG

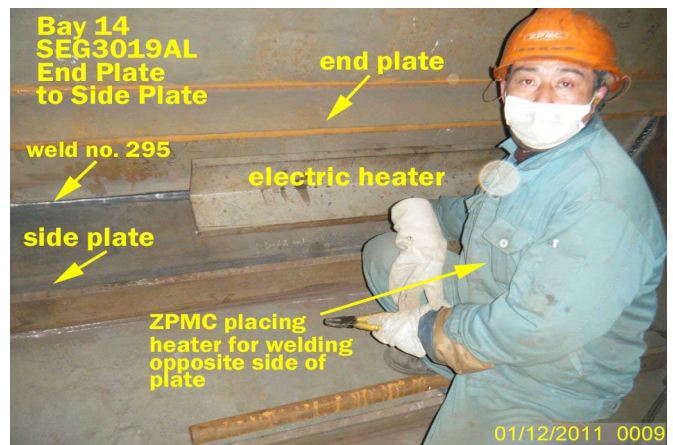
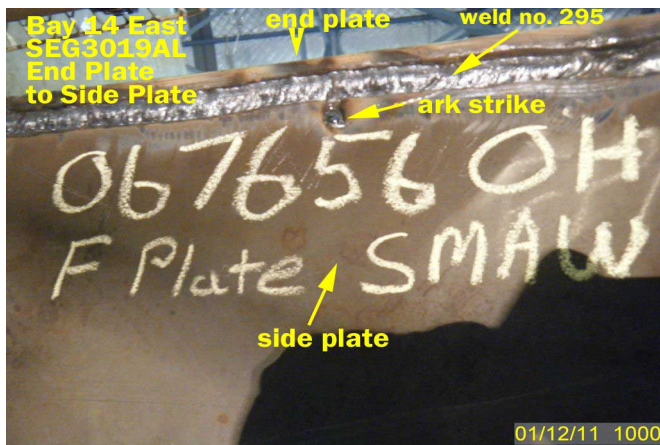
PCMK: SEG3020K

Weld No: 009

Welder: 066734

Weld Repair No. B-WR19830

WPS-345-FCAW-3G(3F)-FCM-Repair



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer